April 22, 2010 2:20:03 PM

Item	ID.
item	117:

D4048-5

Accept



Setup Start

Stop



Revision ID:

Mounting Lug Item Name:

Required Date: 4/30/10

Start Date: • 4/22/10

QC:

Start Oty: 2.00

Reg'd Oty: 2.00,

Date:



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date://>

Tooling:

SPC (Y/N):

Date:

Date:

Stop

Start



Sequence ID/ Work Center ID Operation Description Set Up/ **Run Hours**

Draw Number Rev.

Plan Draw Code

Accept Oty

Reject Reject Otv

Insp. Number Stamp

Draw Nbr Revision/Nbr D4048 Α

100

Bandsaw

Jeaspa Bandsaw

Memo 💸 CUT BLANK 5.330" LONG 0.00

DF 10/05/02

Run

110

HAAS 1

HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND FOLIO FA896 DWG REV:

FOLIO REV:

DEBURR

0.00

0.00

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W/O:			WO	RK ORDER CHAN	GES						
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:PAR #: _		PAR #:	Fault Category:			R: Yes	No DQ	A:	Date:		
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NCR:			WORK ORDE	R NON-CONFORM	IANCE	(NC	R)		*		
DATE	STEP	Description of NC			ction B	C:	Verific	cation	Approval	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign Date		on C	Chief Eng	QC Inspector	
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HandFinish

Hand Finishing

Memo

Page 2

April 22, 2010 2:20:03 PM Item ID: D4048-5 Accept Setup Start Revision ID: Stop Mounting Lug Item Name: Start Otv: 2.00 Start Date: 4/22/10 **Cust Item ID:** Reg'd Oty: 2.00 Required Date: 4/30/10 **Customer:** Reference: Run Start Date: _____ Approvals: Tooling: Date: Stop Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Reject Draw Draw Plan Accept Reject Insp. Work Center ID Description Code **Run Hours** Number Rev. Otv Otv Number Stamp 120 OC2- Inspect parts off machine FAI/FAIB 0.00 m-10/05/04 0.00 Memo **Ouality Control** 130 OC8- Inspect parts - second check 0.00 1.A 10/05/05 0.00 Memo **Ouality Control** 140 Chemical Conversion Coat per QSI005 4.1 0.00 =7m/h w/os/os

W/O:			WO	RK ORDER CHANG	GES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	•	PAR #:	Fault Categ	ory:	NCI	R: Yes	No DQ	A :	_ Date: _	
	Re	esolution:	Disposition	:	QA	: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCF	R)			
DATE	STEP	Description of NC	Corrective Action Section B			Sign 8		cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	***********	Date	Secti	on C	Chief Eng	QC Inspector
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April 22, 2010 2:20:04 PM Item ID: D4048-5 Accept Setup Start Revision ID: Stop Item Name: Mounting Lug 4/22/10 Start Oty: 2.00 Start Date: **Cust Item ID: Reg'd Oty: 2.00** Required Date: 4/30/10 Customer: Reference: Start Run Process Plan: Approvals: Date: Tooling: Date: Stop Date:_____ SPC (Y/N): Date: Sequence ID/ Operation Set Un/ Draw Plan Reject Draw Accept Reject Insp. Work Center ID Description Qty Run Hours Number Rev. Code Otv Number Stamp 150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00 -> M- 10/08/06 M114207 0.00 Powdercoat Memo Powder Coating C***Mask 0.257" holes and indicated channel prior to powder coat*** POWDER COAT: Start Time: 9:1/JAM Oven Temperature: 370°6 BR 10-56. Finish Time: 9 14 500 160 QC3- Inspect Part Finish 0.00 OC 0.00 Memo Quality Control

170

Packaging

Packaging

Identify as per dwg & Stock Location 60

0.00

Memo

0.00

10-5-6 8/

W/O: WORK ORDER CHANGE			ES							
DATE	STEP	PROCEDURE CHANGE			Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Y	es N	lo DQ	A:	_ Date: _	
	R	Resolution: Disposition:				Clos	sed:	****	Date:	
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (N	CR)				
DATE	STEP	Description of NC	Description of NC Corrective Action			ction B Ve			Approval	Approval
DAIL	SILP	Section A	Initial Chief Eng	Initial Action Description Chief Eng Chief Eng		n & ate	Section C		Chief Eng	QC Inspector
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Work Order ID 58067



Page 4

April 22, 2010 2:20:04 PM

Required Date: 4/30/10

T 4	ID
item	

D4048-5

Accept



Setup Start

Stop



Revision ID:

Item Name:

Mounting Lug

Start Date:

4/22/10

Start Qty: 2.00

Req'd Qty: 2.00



Date:_____

Cust Item ID:

Customer:

Draw

Number

Reference:

AD	provals:	

Operation

Description

Date:

Tooling:

Date:

Draw

Rev.

Start Run



SPC (Y/N): Set Up/

Run Hours

Date:

Plan

Code

Accept

Qty

Reject Reject Qty

Stop

Insp. Number Stamp

Sequence ID/ **Work Center ID**

180

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

Quality Control

	-								
W/O:	W/O: WORK ORDER CHAN								· · · · · · · · · · · · · · · · · · ·
DATE	STEP PROCEDURE CHANGE		ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No		PAR #:							
	R	esolution:						Date: _	
NCR:			WORK ORI	DER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC	Corrective Action Section B			Verifi	cation	Approval	Approval
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Picklist Print

April 22, 2010 2:20:02 PM

Work Order ID: 58067

Parent Item:

D4048-5

Parent Item Name: Mounting Lug

Comments:

IPP REV:A NEW ISSUE JLM 10-01-26 VERIFIED BY:EC

as per dwg revA DD 10.02.18 verified by:EC

IPP Rev:B

Start Date: 4/22/10

Required Date: 4/30/10

Start Oty: 2.00

Required Oty: 2.00

Component Item ID/ Item Name

M6061T6B1.500X04.00

Replacement Mfg/ Item ID

Purch Purchased

Bin Primary Item Location No

Last Location Route Seq ID 100

Unit of

17

Oty on Measure Hand 17.0000 Remaining Otv Qty To Pick Issued 0.9347

Date Issued

Status

Page 1



6061T6 Bar 1.500 x 4.00

Warehouse Loc Oty Loc Code

Location

Main Warehouse

MAT09

113797

17

<u>.9347</u> 8/ 10/06/02

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W/O:			WC	RK ORDER CHANG	GES					
DATE STEP		PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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							-, -p. 1818-			
Part No	•	PAR #:	Fault Cate	gory:	NCF	: Yes	No DQ	A :	_ Date: _	
	Re	solution:	Disposition	n:	QA:	N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC	Corrective Action Section B			0: 0	Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	58067
	· · · · · · · · · · · · · · · · · · ·	
Description: Alounting Lug	Part Number:	04048-5
Inspection Dwg: 04048 Rev: A		Page 1 of 1

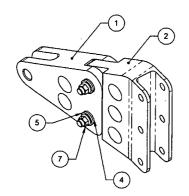
FIRST ARTICLE INSPECTION CHECKLIST

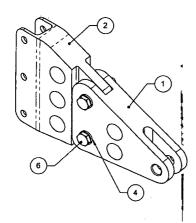
X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.11	£0. ±	5.14	V.51.			
-875	± .0/0	.879	V			
1.38	\$0. t	1.375				
-115	t.010	. 1/7	<u> </u>			747
.770	+ 10/0	768				0
1.00	±.03	1.00	✓			REF
.293	c/o. ±	.386				2 br
धार्य	+.015000	.466.	/			
3.75	± .03	3.745				
3.000	± .010	2.998	V			
1.500	0/0, ±	1.501	✓			
85.	± .03·	.37	√			
.375	2 .010	.374	V			
Ø .257	1.006, 000.	.969	~			
2.34	±.03	2.34	✓			
1.63	± .03	1.63	V			
2.67	±.03	2 27		-		- NO
. 145	210, ±	.125	V			TYP
.43	£0, ±	£15.	\	ļ		441
Ø .375	too = ood	Ø .377	/			
8.435×45°	±.010/±%°	8 430× 45°	~			

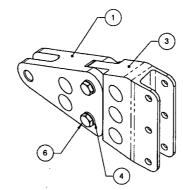
Measured by:	MU	Audited by:	y.a	Prototype Approval:	· N/A
	10/05/04	Date:	10/05/05	Date:	N/A

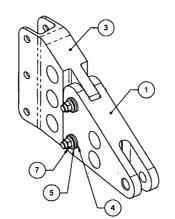
Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	





D4048-041 MOUNTING LUG ASSY (SHOWN)





D4048-042 MOUNTING LUG ASSY (SHOWN)

ITEM	QTY -041	QTY -042	P/N	Description	_
	X		D4048-041	MOUNTING LUG ASSY	
		х	D4048-042	MOUNTING LUG ASSY	
1	1	1	D4048-1	MOUNTING LUG	_
2	1		D4048-3	MOUNTING LUG	
3		1	D4048-4	MOUNTING LUG	_
4	4	4	D4048-9	BUSHING	
5	2	2	AN960JD416	WASHER	
6	2	2	AN4-14A	BOLT	
7	2	2	MS21042L4	NUT	_

2

SHOPECTY

RETUR" (4)

ENGINE THE

UNCONTROLL FOR COME

SUBJECT TO AMPRICAGE 1

WITHOUT MODILET

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Α.	NEW IS	SUE	RF	10.01.29			
REV.			DESCRIPTION	BY	DATE		
DESIG	4	RF	DART AEROSPAC	^F	ITD		
DRAW	V	RF	HAWKESBURY, ONTARIO,				
CHECK	ED	P	DRAWING NO.		REV. A		
MFG. A	PPR.	91	D4048		SHEET 1 OF 9		
APPRO	VED	NP	TITLE		SCALE		
DE APP	PR.	-#	MOUNTING LUG ASSY				
DATE	10.0	1.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS EUPPLED ON THE EUPPLES CONDITION TH NOT TO BE USED FOR ANY PURPOSE OR COPED OR COMMUNICATED TO ANY OTHER PERSON WIT				

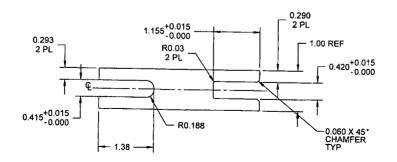
NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4048-041/-042" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: D4048-041/-042: 1.16 lbs
8) TORQUE AN4 BOLTS TO 50-70 in-lbs (5.6-7.9 Nm)

5

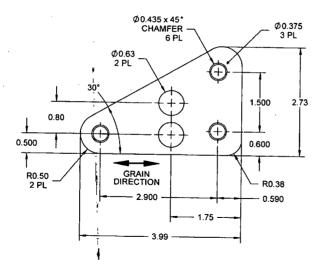
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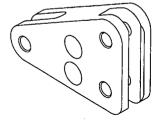
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Ye	s No De	QA:	Date: _	
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DATE	STEP	Description of NC		ction B	Veri	fication	Approval Chief Eng	Approval	
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D4048-1 MOUNTING LUG



Wlo 58067

DESIGN	RF	DART AEROSPACE	ITD
DRAWN	RF	HAWKESBURY, ONTARIO, CAN	
CHECKED	W	DRAWING NO.	REV. A
MFG. APPR.		D4048	SHEET 2 OF 9
APPROVED	143	TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
DATE 10.0	1.29	COPYRIGHT © 2010 BY DART AEROSPA THIS DOCUMENT OF PRIVATE AND COMPOSITION AND IS SUPPLIED ON THE EXP NOT TO BE USED FOR ANY PURPOSE OR COMPET ON COMPANICATED TO ANY	REFER CONCETTON THAT IT IS

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NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
MASK Ø0.315 HOLES PRIOR TO POWDER COAT
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A

7

6) IDENTIFICATION: N/A 7) WEIGHT: 0.47 lbs

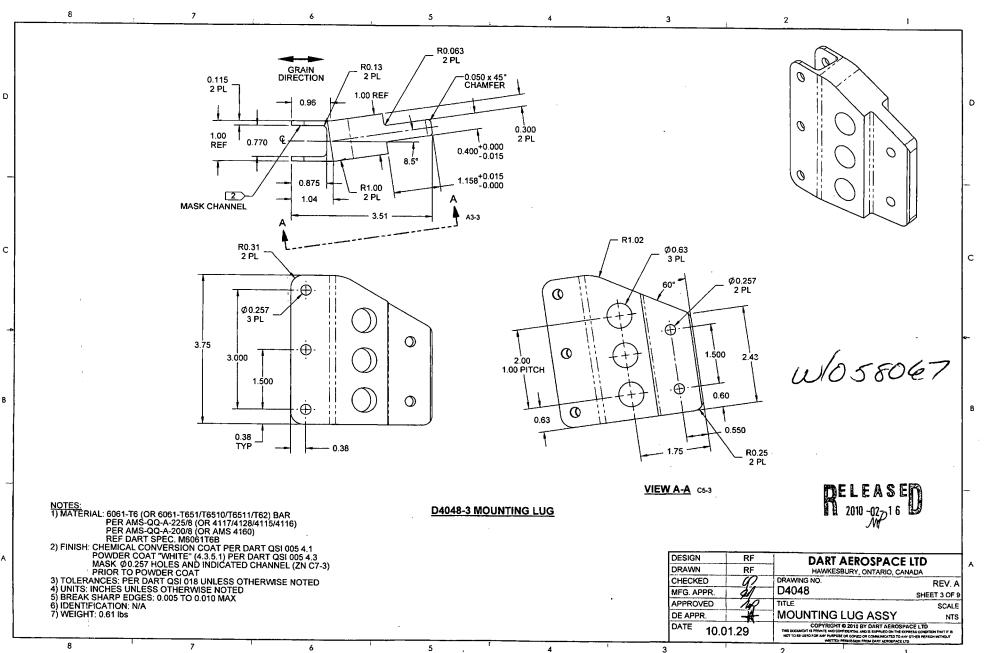
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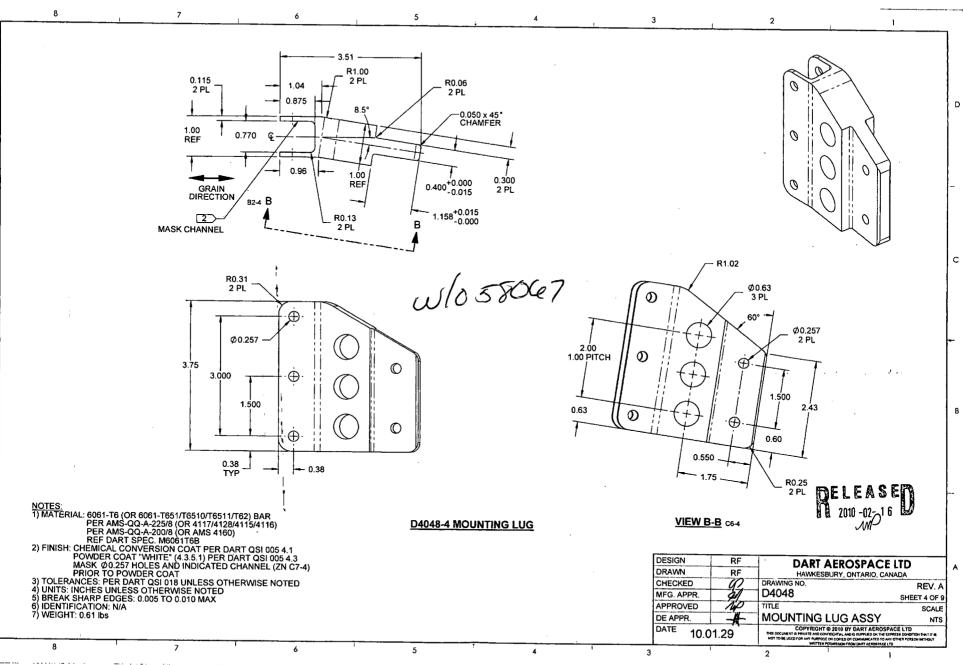
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DATE	STEP	Description of NC		on B	Verifi	cation	Approval	Approval	
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	on Sign & Date		ion C	Chief Eng	QC Inspector
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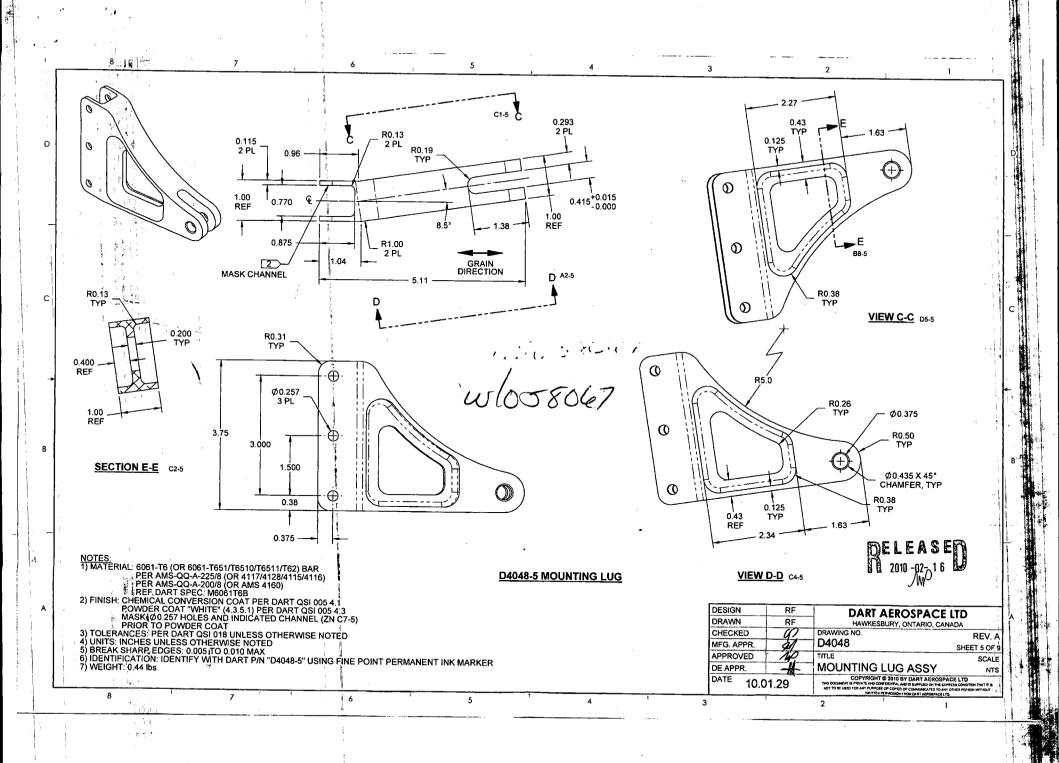


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DATE	STEP	Description of NC		tion B		Verific	cation	Approval	Approval	
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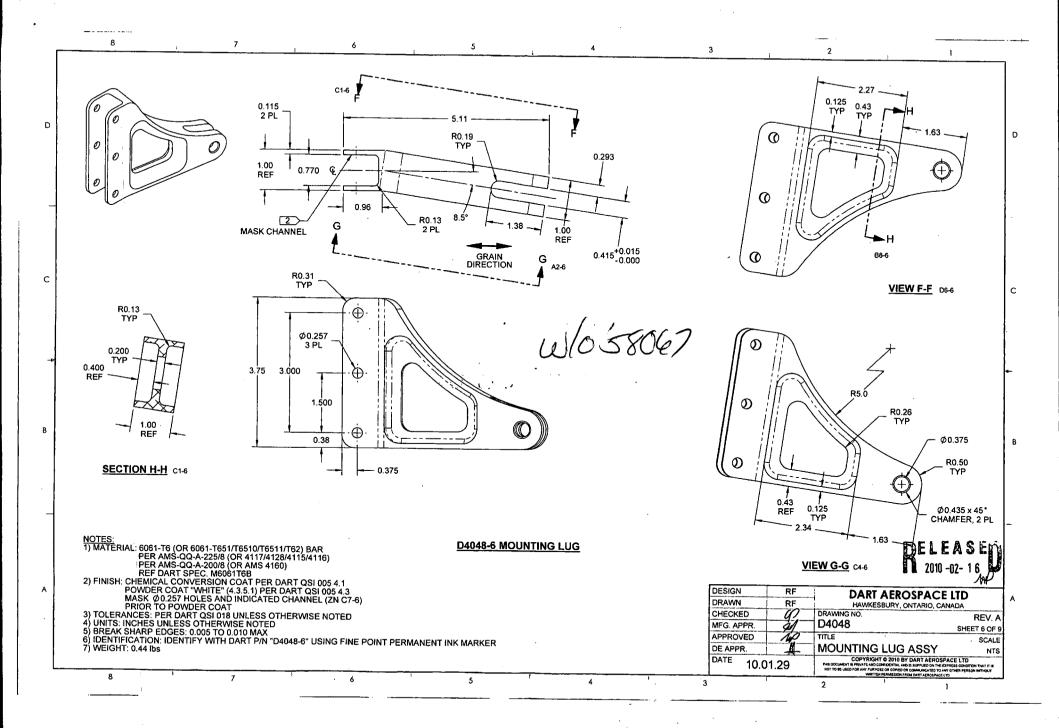


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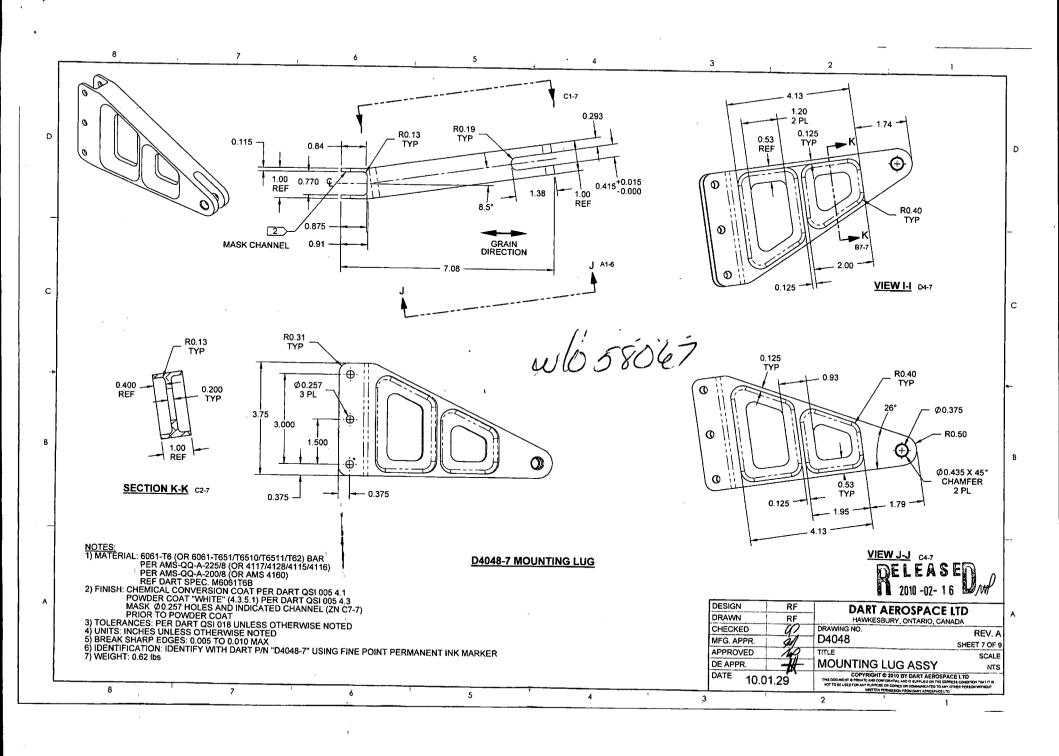
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:								
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NCR:			WORK ORDI	ER NON-CONFORM	ANCE	(NCR)			-			
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NCR:			WORK ORDE	ER NON-CONFORM	ANCE (NC	₹)						
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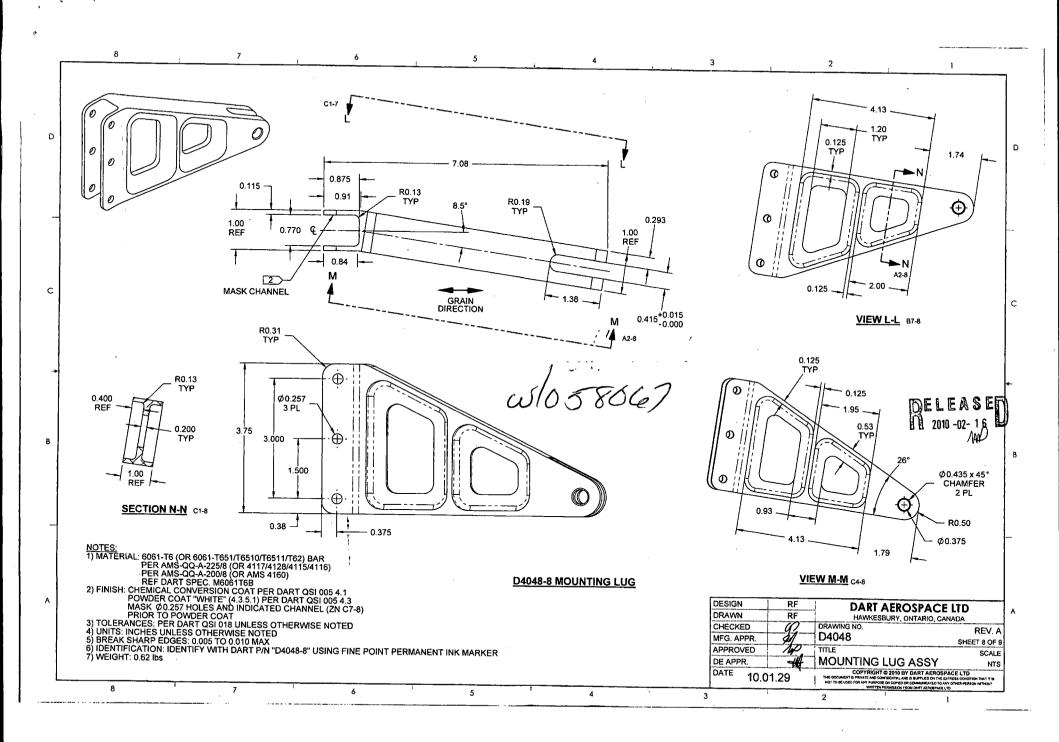


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DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
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NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
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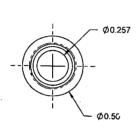


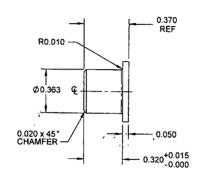
Dart Aerospace	Ltd
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NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCP	3)			
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Part No: PAR #:		PAR #:	Fault Cated	NCR: Ye	NCR: Yes No DQA: Date:				
Resolution:			Disposition:			QA: N/C Closed: Date:			
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)			
DATE	STEP	Description of NC		Corrective Action Section B			/erification	cation Approval	Approval
DATE	OIL!	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section C	Chief Eng	QC Inspector
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						-			
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D4048-9 BUSHING

w/o 58067



NOTES:
1) MATERIAL: AISI 303 STAINLESS STEEL BAR
REF DART SPEC. M303B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

7

8

DESIGN	RF	DART AEROSPACE	LTD				
DRAWN	RF_	HAWKESBURY, ONTARIO, CANADA					
CHECKED	P.	DRAWING NO.	RFV A				
MFG. APPR.	91	D4048	SHEET 9 OF				
APPROVED	140	TITLE	SCALE				
DE APPR.	-#	MOUNTING LUG ASSY	NTS				
DATE 10.0	1.29	COPYRIGHT © 2010 BY DART AEROSP THIS DOCUMENT IS PRIVATE AND CONFEDENTIA, AND IS SUPPLIED ON THE DU- NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO AN	PRESS COMPETION THAT IT IS				

W/O:		WORK ORDER CHANGES										
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Part No: PAR #:		Fault Category: NO			NCR: Yes No DQA:			Date:				
	Resolution: Disposition: Q				QA: N/C Closed: Date:							
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DATE	STEP	Description of NC Section A	Corrective Action Section B Initial Action Description Chief Eng Chief Eng			Sign &	Verification Section C		Approval Chief Eng	Approval QC Inspector		
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